Work Order ID 706 Monday, June 13, 2011 1:36:0								Page 1	l
Item ID: D3493-1 Revision ID: Item Name: Washer			Accept			s	etup Start Stop		
	Start Qty: 60.00 Req'd Qty: 60.00	1 1 1 1 1 1 1 1 1 1		Cust Item 1 Customer:			,		
Approvals: Process Plan QC:	/ (ate: <u>//-0/2-/3</u> ate:	Tooling: SPC (Y/N):	, per	Pate:	R -	dun Start Stop		
	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan			Reject Insp. Number Stamp	
	ion Nbr								_
D3493 Rev A	1						/		
Hardinge CNC Lathe Small	Hardinge CNC LATHE SMA Memo 1-Turn as per Fol	LL io FA626 & Dwg D349	0.00 0.00 03D2-Deburr	123		60	þ		
110 QC Quality Control	QC2- Inspect parts off machin	e FAI/FAIB	0.00 0.00 \(\) \(\) \(\) \(\) \(\) \(\)	23		60	6		
120 QC Quality Control	QC8- Inspect parts - second c	neck Stage	0.00	11.6.	23	· <u>&</u>	4		

W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								•	
Part No.		DAD #.	Foult Cat		NCD: Voc	No DO	<u> </u>	Dete	
Part No: PAR #:									
		esolution:						Date:	
NCR:			WORK ORE	PER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
DAIL	0.21	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	Section C C	Chief Eng	QC Inspector
				•					
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1									1

Work Order ID 70697

Monday, June 13, 2011 1:36:04 PM



Page 2

Item ID:

D3493-1

Washer

Item Name: **Start Date:**

Revision ID:

6/13/2011

Start Qty: 60.00 Required Date: 6/20/2011

Operation

Req'd Qty: 60.00

Accept



Setup Start

Stop



Reference:

Approvals:

QC:

Process Plan:

Tooling: Date:

SPC (Y/N):

Set Up/

Cust Item ID:

Customer:

Tool ID

Date:

Tool # Plan

Date:

Start



Stop

Description Identify as per dwg & Stock Location: 5762

Date:

0.00

Run Hours

Code

Accept Reject Qty Qty

Run

Reject Number Stamp

Insp.

Sequence ID/

Work Center ID

Packaging

Packaging

130

Memo

0.00

140

OC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dail Aci	Ospace	ELLU							. 1	
W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								-		
		,								
								<u> </u>		
Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	s No DQ	A: Date:			
Resolution:			Disposition: QA			Closed:		Date: _		
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NC	R)				
DATE	OTED	Description of NC	Corrective Action Section B			Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	l& ∣ _{Sect}	ion C	Chief Eng	QC Inspector	
		·								
							· · · · ·			
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Picklist Print

Monday, June 13, 2011 1:36:11 PM

Work Order ID: 70697

Parent Item:

D3493-1

Parent Item Name:

Washer



Start Date: 6/13/2011

Required Date: 6/20/2011

Page 1

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev: A New Issue 06-02-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primai Item Locati	 Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.000		Purchased	No	100	f	64.4500	0.0291	1.837895	1,5	2/23	2

304 round bar 1.00

Location	Loc Qty	Loc Code
MAT029	64.45	
109508	12.5	
109508 1095412 1134575	3.78	
1134573	48.17	

1.6-6+

	oopaot) = (u							,	
W/O:			V	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							-			
Part No:		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date: _		
			Disposition: QA			QA: N/C Closed: Date:				
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)				
DATE	CTED	Description of NC						Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Sect	ion C	Chief Eng	QC Inspector	
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		,								
			,	•				,		

DART AEROSPACE LTD	Work Order:	70697
Description: Washer	Part Number:	D3493-1
Inspection Dwg: D3493 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.192	+0.000/-0.005	192			PNR	
Ø1.000	+/-0.010	0,995			1	·
Ø0.958 x 100°	+/-0.010	D.958x100			/	
Ø0.516	+0.008/-0.001	1,520				
		70.00			<u>-</u> ,	
<u> </u>						

Measured by:	12	Audited by:	Prototype Approval:	N/A
Date:	4/6/23	Date: 11.6.23	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	
В	06.11.22	Ø0.516 dimension removed	KJ/JLM 1.A	
С	08.04.30	Dimensions updated	KJ/DD O	<i>X</i>

W/O:			WC	ORK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•									
						1			
				×					
		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	ı:	_ Date: _	-
	R	esolution:	Disposition	າ:	QA: N/C Cld	osed:		Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STED	Description of NC Section A		on B	Verificat		Approval	Approval	
DAIL	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
							<u>.</u>		
		,							

NOTE: Date & initial all entries



DESIGN	PH	DRAWN BY	DART	AEROSPACE L		INC.
CHECK	ED M	APPROVED	DRAWING NO.			REV. A
	111	"7	D3493		SH	EET 1 OF 1
DATE			TITLE			SCALE
06.01.04			WASHER			1:1
Α		06.01.04	NEW ISSU	JE		

SHOP CHRY RETURNIN **ENGINEERING**

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE - 0.192^{+0.000} WORK ORDER p111-06-13 Ø1.000 C'SINK -Ø0.958X100° Ø0.516

D3493-1 WASHER

MATERIAL:

AISI 304/316 STAINLESS STEEL Ø1.000 ROUND BAR

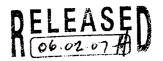
(REF DART MATERIAL SPEC M304R1.000)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3493-1 WASHER

BREAK SHARP EDGES 0.005 TO 0.010 MAX 4)



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Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			V	ORK ORDER CHANG	GES	}				
DATE	STEP	PROCEDURE CHANGE			Ž	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dort No.	<u> </u>	242 //								<u> </u>
Part No		PAR #:								
	R	esolution:	Disposit	ion:	QA:	N/C Clo	sed:	<u></u>	Date:	
NCR:		WC	ORK OR	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section					ation	Approval	Approval
	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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